

Work Order ID 155372-2

155372

Page 1

Thursday, January 12, 2017 3:41:04 PM

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Bracket

Start Date: 1/19/2017

Start Qty: 4.00

4

Required Date: 1/26/2017

Req'd Qty: 4.00

4

Cust Item ID:

Customer:

Reference:

JAN 13 2017

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup

Start

NS1

Stop

NS2

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2341	Rev G								
D2360	Rev D								
100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 12.65" Long								
110	HAAS CNC VERTICAL MACHINING #1	0.03							
110									
HAAS 1	Memo	0.53							
HAAS CNC vertical machine #1	Machine as per Folio D2341 and Dwg D2341 2-Deburr								

10 0

DAS
49
9-89
17/01/24

10 1

DAS
49
9-89
17/01/25

split

4
DAS
36
9-89

Work Order ID 155372***155372***

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Thursday, January 12, 2017 3:41:04 PM

Item ID: D2360

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Litter Tie Down Bracket

Start Date: 1/19/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/26/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.01				10	0		DAS 49 9-89 17/01/25
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				10	0		DAS 08 9-89
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.03				(X10)	0		2017/02/09 BEB

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Item ID: D2360**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Litter Tie Down Bracket**Start Date:** 1/19/2017 **Start Qty:** 4.00 ***4*****Cust Item ID:****Required Date:** 1/26/2017 **Req'd Qty:** 4.00 ***4*****Customer:****Reference:**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:43,5,1) per OSI 905 4.3-Alum	0.00							
150	<i>m 136854</i>					<i>10</i>	<i>0</i>	<i>1702-15</i>	<i>35 34 9-89</i>
Powdercoat	Memo	0.03							
Powder Coating	START TIME: <i>1:05</i>								
	OVEN TEMPERATURE: <i>300°</i>								
	FINISH TIME: <i>1:35</i>								
160	QC3- Inspect Part Finish	0.00							
160									<i>DAS 38 9-89</i>
QC	Memo	0.01				<i>10</i>			
Quality Control									
170	Small Fab	0.00							
170									
Small Fab	Memo	0.16				<i>4X</i>			<i>17/03/13</i>
Small Fab	Assemble as per dwg D2360								<i>DAS 36 9-89</i>

FEB 17 2017

Drill Holes
#D .246
DAS 22 9-89
17.02.17

Work Order ID 155372

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Page 4

Item ID: D2360

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Litter Tie Down Bracket

Start Date: 1/19/2017 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 1/26/2017 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									DAS 38 9-89
QC	Memo	0.01				4			
Quality Control									MAR 13 2017
190	Identify as per dwg & Stock Location: St225	0.00							
190									
Packaging	Memo	0.01				4			
Packaging									MAR 13 2017 DAS 6 9-89
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.07							
Quality Control									17/3/14 df

DAS
21
9-89
MAR 14 2017

Picklist Print

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Page 1

Work Order ID: 155372

155372

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 1/19/2017

Required Date: 1/26/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev H 07.06.12 ecn 825 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R18		Purchased	No			170	Each	154.0000	1	4	DAS 30 9-89	MAR 02 2017	
AN526C1032R18									**				
Screw													

Location Loc Qty Loc Code

FP001	72	
4523	72	
ST327	82	
108079	82	10

D2002-015

Manufactured No

170

Each

8.0000

2

8

DAS
30
9-89

MAR 02 2017

D2002-015

Knob

Location Loc Qty Loc Code

GA	8	B155586
140144	3	
148284	5	

13

DAS
30
9-89
B157256 74

D2345

Manufactured No

170

Each

12.0000

1

4

DAS
30
9-89

MAR 02 2017

D2345

Lock Channel

Location Loc Qty Loc Code

GA	12	B156775
136913	2	
144888	5	
151355	5	2

8

Picklist Print

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Page 2

Work Order ID: 155372

Parent Item: D2360

Parent Item Name: Litter Tie Down Bracket

155372

D2360

Start Date: 1/19/2017

Required Date: 1/26/2017

Start Qty: 4.00

Required Qty: 4.00

D2366

Manufactured No

170

Each

18.0000

2

8

30

9-89

D2366

Lock Handle

**

MAR 02 2017

Location

Loc Qty

Loc Code

ST006

18

151361

12

153985

6

D2367

Manufactured No

170

Each

7.0000

1

4

DAS

30

9-89

D2367

Handle Knob

**

MAR 02 2017

Location

Loc Qty

Loc Code

ST006

7

140046

1

151353

6

D2372

Manufactured No

170

Each

18.0000

2

8

DAS

30

9-89

D2372

Quick Release

**

MAR 02 2017

Location

Loc Qty

Loc Code

GA

18

140024

2

152329

16

D2373

Manufactured No

170

Each

10.0000

1

4

DAS

30

9-89

D2373

Spring

**

MAR 02 2017

Location

Loc Qty

Loc Code

GA

10

148165

10

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Shop Packet Print

Page 2

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Work Order ID: 155372

Parent Item: D2360

Parent Item Name: Litter Tie Down Bracket

155372

D2360

D2444

Manufactured No

D2444

Pip Pin Assembly

Start Date: 1/19/2017

Required Date: 1/26/2017

Start Qty: 4.00

Required Qty: 4.00

170 Each 3.0000 1 4

**

DAS
30
9-89

MAR 02 2017

Location

GA 152310

Loc Qty

3
3
100 f

Loc Code

B 155599 (3)
B 156849 (4)
13.3110

1.054

4.437895

**

DAS
49
9-89

17/01/24

D6201

Manufactured No

D6201

"T" Extrusion

Location

MAT028
124165
141301
148847

Loc Qty

13.3110001
0.0000001
0.675
12.636

Loc Code

185.0000

**

10.58 + 1.387
4

MS20470AD3-4

Purchased No

MS20470AD3-4

Rivet, Universal Head

Location

ST310
111477

Loc Qty

185
185

Loc Code

DAS
30
9-89

MAR 02 2017

10

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Shop Packet Print

Page 3

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Page 4

Work Order ID: 155372

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Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

MS21042L3

Purchased No

Start Date: 1/19/2017

Required Date: 1/26/2017

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Nut

170 Each 2,111.000 3 12

DAS
30
9-89

MAR 02 2017

Location

Loc Qty

Loc Code

FP001		100
m135945		100
GA		162
m134360		108
m135135		54
OVER007		500
M136554		500
ST303		1349
M136044		249
M136192		600
M136406		500

M136665 30

MS27039-1-13

Purchased No

562.0000 1 4

DAS
30
9-89

MAR 02 2017

MS27039-1-13

Screw

Location

Loc Qty

Loc Code

GA		44
124326		44
over006		300
124326		300
ST280		218
125654		218

10

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Work Order ID: 155372

Parent Item: D2360

Parent Item Name: Litter Tie Down Bracket

155372

D2360

MS27039-1-15

Purchased No

MS27039-1-15

Screw

Start Date: 1/19/2017

Start Qty: 4.00

Required Date: 1/26/2017

Required Qty: 4.00

170 Each 265.0000 2 8

**

DAS
30
9.89

MAR 02 2017

Location

Loc Qty

Loc Code

GA
m127916
over006
m136554
ST280
m134852
m136406

1
1
100
100
164
64
100

1
119

170 Each 1,394.000 8 32

**

DAS
30
9.89

MAR 02 2017

Location

Loc Qty

Loc Code

FP001
m134848
GA
m134848
ST264
m135672
m136015

92
92
122
122
1180
26
1154

8068

DAS
36
9.89
136683
12x

NAS1149D0363J

Purchased No

NAS1149D0363.J

Washer

170 Each 1,217.000 2 8

**

DAS
30
9.89

MAR 02 2017

Location

Loc Qty

Loc Code

GA
m134055
ST263
m135864
m136318

272
272
945
9
936

20

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Picklist Print

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Page 6

Work Order ID: 155372

Parent Item: D2360

Parent Item Name: Litter Tie Down Bracket

155372

D2360

Start Date: 1/19/2017

Required Date: 1/26/2017

Start Qty: 4.00

Required Qty: 4.00

NAS679A3W

Purchased

No

170

Each

175.0000

1

4

DAS

30

9-89

NAS679A3W

Nut

MAR 02 2017

Location

Loc Qty

Loc Code

GA

53

M2409

53

Mezz

122

2409

122

60

Thursday, January 12, 2017 3:41:04 PM

Shop Packet Print

Page 6

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS SCALE	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

RELEASED07.06.07 **[Signature]****PARTS LIST:**

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT



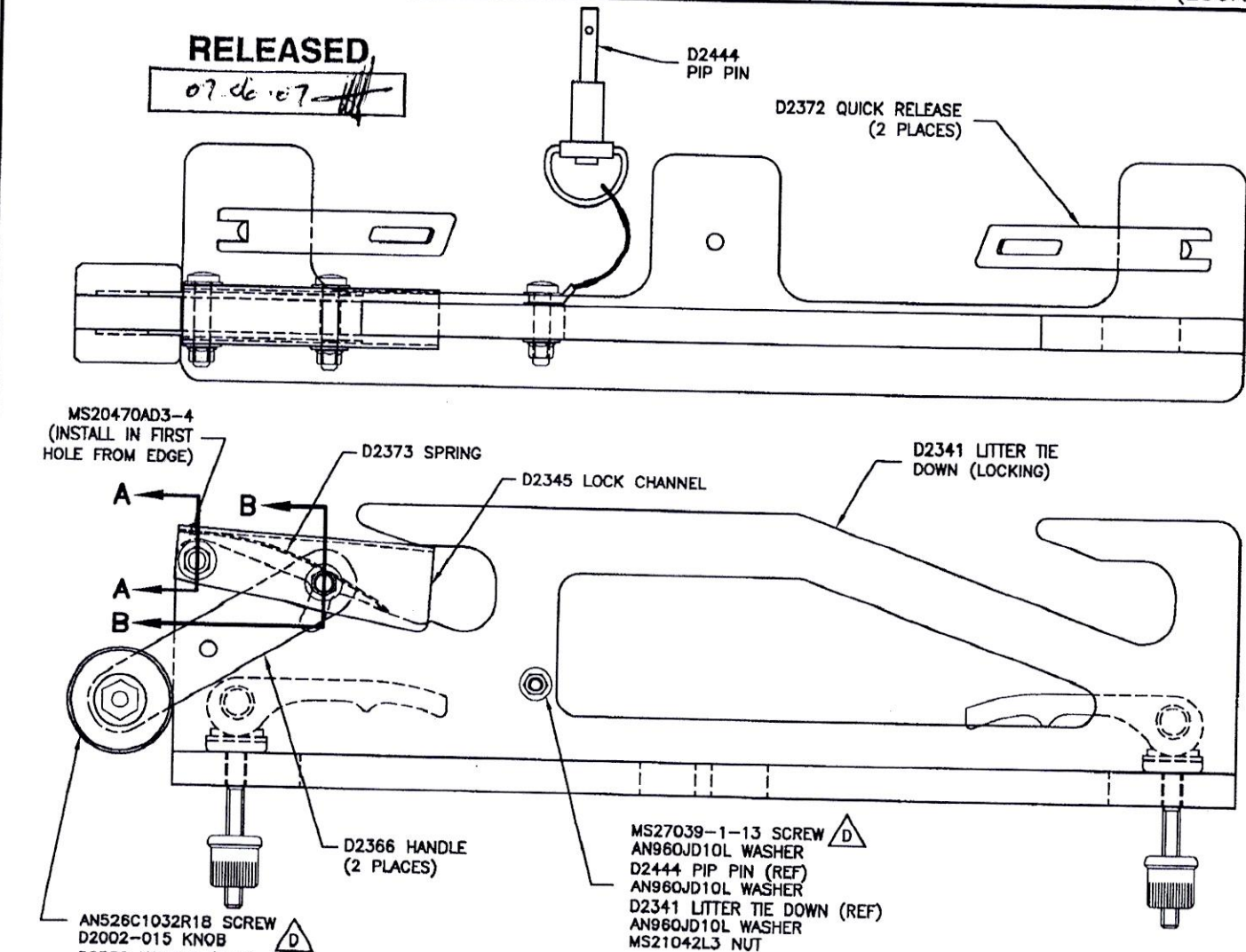
SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
155372

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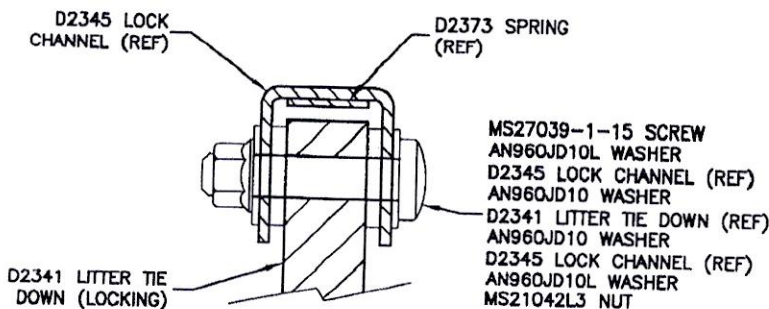
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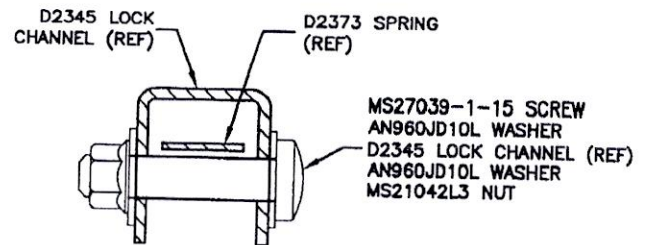
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D2360	REV. D SHEET 2 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	SCALE



D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)



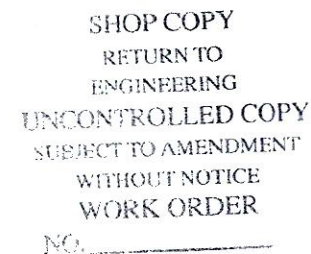
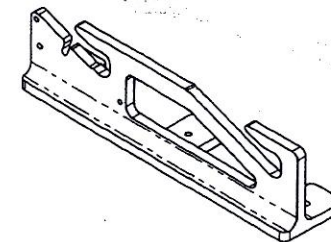
SECTION A-A
(SCALE 1:1)



SECTION B-B
(SCALE 1:1)

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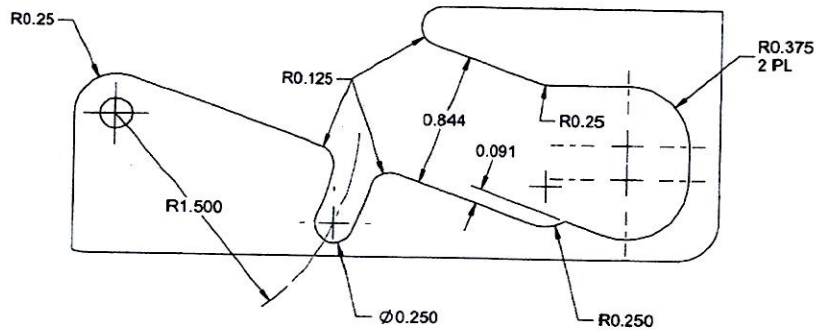


NOTES:
1) MATERIAL: MAKE FROM D6201-125 EXTRUSION
REF. 6061-T6T651 PER QQ-A-200/8
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2341" AND B/N "BXXXXXX" ON BOTTOM FACE PER QSI 044 6.1
7) WEIGHT: 1.64 lbs

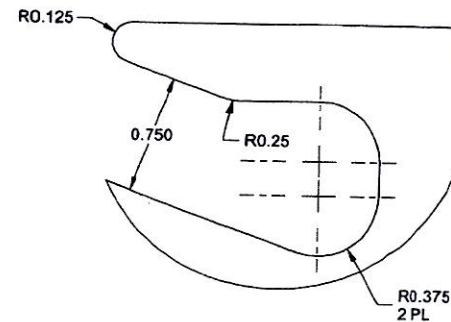
RELEASED
2016-04-18
EON 11-562

APPROVED

G	REFORMAT TO CURRENT STD; Ø0.246 WAS Ø0.242. REASON: PAR15-415.	MB	15.11.12
F	REVISED NOTES; FINISH WAS ANODIZE	DC	07.06.07
E	CHANGES FOR MACHINING	KE	97.10.01
D	CHANGES TO DIAMETERS	KE	95.02.20
B	MODIFIED LOCK	BW	95.02.14
A	NEW ISSUE	BW	95.01.13
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AJS	DRAWING NO.	REV. 0
MFG. APPR.	JLM	D2341	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LITTER TIE DOWN BRACKET (LOCKING)	NT
DATE	15.11.12	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



DETAIL A
SCALE 2X C6-1



DETAIL B
SCALE 2X C4-1

RELEASED
2016-04-18

APPROVED

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AJS	DRAWING NO.	REV. G
MFG. APPR.	JLM	D2341	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LITTER TIE DOWN BRACKET (LOCKING)	NTS
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